

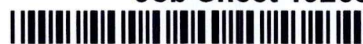


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D3140-98

Job Sheet 192631



Part No: D3140-98

Job Qty: 4 pcs ✓

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/28/19

Job Tracking No: Order 13294

Due Date: 4/26/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV F IPP A 02.04.30 New Issue NG IPP Rev B IPP Rev: C Now on Waterjet 06-06-08 JLM IPP rev.D
added scuffing NCR 061 EC IPP Rev: B As per ECN #829 06-11-20 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		4/26/19	0.00	0.00	Waterjet - Flow		DL 19/02/13
110	QC 2	4 pcs		4/26/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		DL 19/02/13
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		
							QC 2 - 5		
120	QC 8	4 pcs		4/26/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		

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				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
130	Small Fab - 2 - B4B	4 pcs	4/26/19	0.00 0.00	Small Fab - 1 - B4B
					Small Fab - 2 - B4B
					Small Fab - 3 - B4B
					Small Fab - 4 - B4B
					Small Fab - 5 - B4B
					Small Fab - 6 - B4B
					Small Fab - 7 - B4B
140	QC 5	4 pcs	4/26/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
150	Handfinish - 1-1 Chemical-B4B	4 pcs	4/26/19	0.00 0.00	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B
					Handfinish - 1 - 19 - B4B
					Handfinish - 1 - 20 - B4B

DAS
40
9-89

JUN 14 2019

DAS
30
9-89

JUN 17 2019

DAS
40
9-89

JUN 17 2019

JUN 18 2019

160 QC 3	4 pcs	4/26/19	0.00 0.00	Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
170 Packaging 3-1 - Stock - B4B	4 pcs	4/26/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	pc GATBD
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
180 QC 21 - SA	4 pcs	4/26/19	0.00 0.00	QC 21 - SA - 21	GATBD
				QC 21 - SA - 70	21
				QC 21 - SA - 53	JUN 19 2019

Part Op 100 - 1-Cut as per Dwg D3140 **Ensure grain direction is correct***** Dwg Rev: F-55 Prog Rev: F 2-Deburr

Descriptions: if necessary

- 110 - (QC2- Inspect parts off machine FAI/FAIB)
- 120 - (QC8- Inspect parts - second check)
- 130 - (Small Fab) 1-Form as per Dwg D3140 2-Scuff surfaces with 80grit sandpaper per QSI 006 3-Deburr. No sharp edges
- 140 - (QC5- Inspect part completeness to step on W/O)
- 150 - (Chemical Conversion Coat per QSI005 4.1)
- 160 - (QC3- Inspect Part Finish)
- 170 - (Identify as per dwg & Stock Location: _____)
- 180 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.032	2024-T3 .032 Sheet	.6840 sf (.171 ea)	100-Waterjet - Flow - 1	5013848

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.032	1	217	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	6.400inches $\pm$ 0.030	6.430 6.370		
2	Doubler	3.810inches $\pm$ 0.030	3.840 3.780		
3	Doubler	5.250inches $\pm$ 0.030	5.280 5.220		
4	Doubler	1.740inches $\pm$ 0.030	1.770 1.710		
5	Doubler	0.550inches $\pm$ 0.030	0.580 0.520		

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Container No: S190018



Part: D3140-98

Job No: 192631

Serial No/Batch: S190018

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 06/13/19